

3050



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DEBUTATION
QTY 1

RB T101896-13
Job Sheet 178326



JL SCHMIDT

O/S

SHIP 7-13

No FAIL

Part No: RB T101896-13

Job Qty: 6 ea

Part Name: Grip Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/30/18

Job Tracking No:

Due Date: 6/18/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB T101896 Rev A IPP Rev A 18.03.27 New issue DP Verify DD/IPP Rev. B 18.05.24 New DWG update
DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	6/18/18	6/18/18	0.00	0.00	Start Up Machining-2		JK
110	CNC Lathe	6 pcs	6/18/18	6/18/18	0.00	3.00	MORI SL2500Y		JK
120	QC	6 pcs	6/18/18	6/18/18	0.00	0.00	QC2 Machining-4		JK
130	QC	6 pcs	6/18/18	6/18/18	0.00	0.00	QC8 Machining-4		JK
150	Outsource	6 pcs	6/18/18	6/18/18	0.00	0.00	Outsource 13		JK
160	Packaging	6 pcs	6/18/18	6/18/18	0.00	0.00	Packaging 2		JK
170	QC	6 pcs	6/18/18	6/18/18	0.00	0.00	QC2		JK
180	Packaging	6 pcs	6/18/18	6/18/18	0.00	0.00	Packaging 3		JK
190	QC21-SA	6 Ea	6/18/18	6/18/18	0.00	0.00	QC21		JK

Part Op 110 - 1-Machine as per DWG. FC123 FOLIO REV: _____ DWG REV: _____ Z-Debut

Descriptions: 150 - Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Material type; 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-R4.000	AISI 4140 Round Bar	3.2460 ft (.541 ea)	90-Start up Operation	5066896-1.16

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-R4.000	3	13	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/22/18 10:49 AM dart.logan.david

Container No: S091897



Part: RB T101896-13

Job No: 178326

Serial No/Batch: S091897

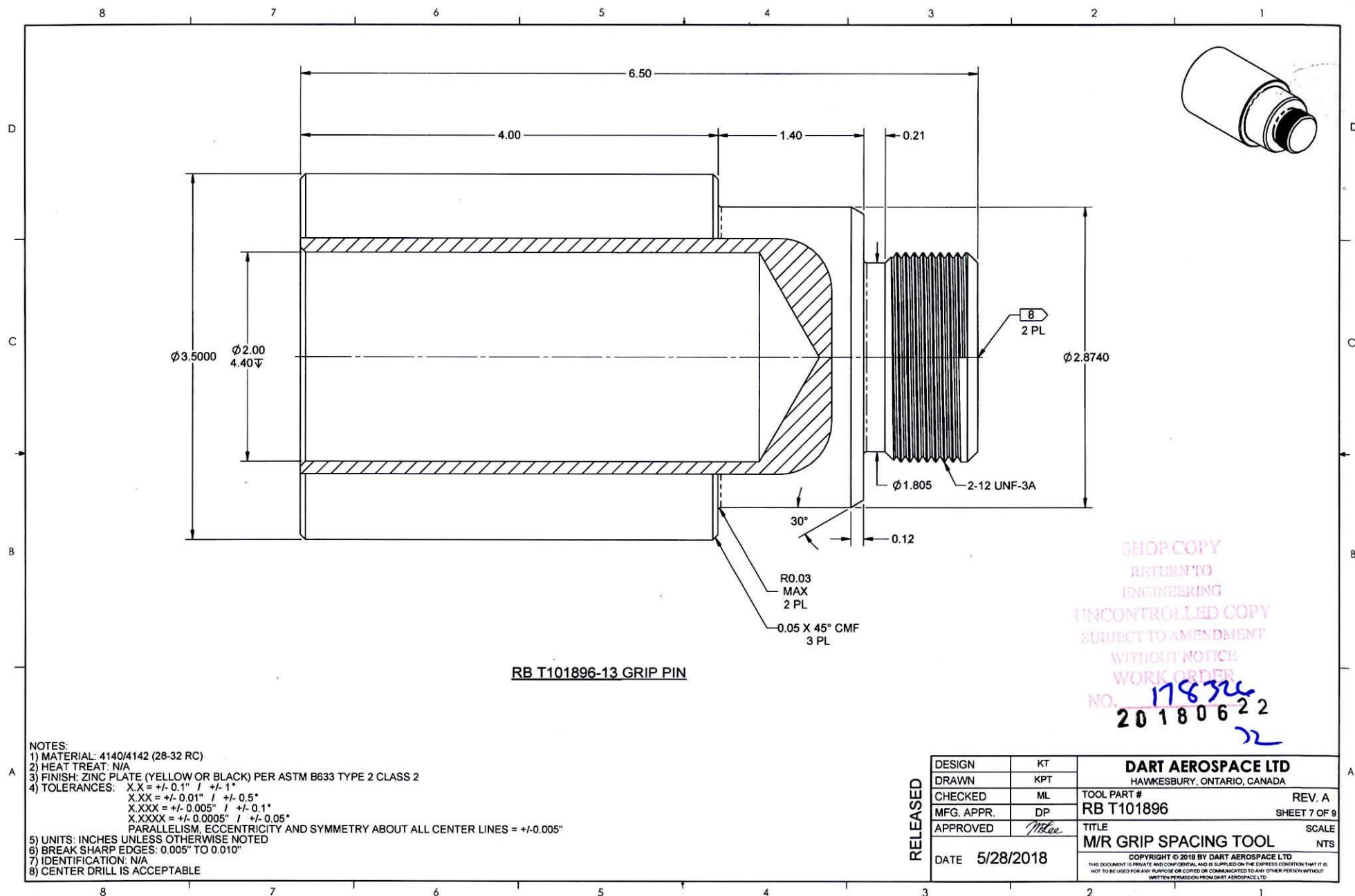
Revision: A

Inspector:

Exp Date:

Instructions:

Date: 07/16/18



SHOP COPY
 RETURN TO
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 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 178326
 20180622

RELEASED	DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	KPT		
	CHECKED	ML	TOOL PART #	REV. A
	MFG. APPR.	DP	RB T101896	SHEET 7 OF 9
	APPROVED	<i>M. Lee</i>	TITLE	SCALE
	DATE	5/28/2018	M/R GRIP SPACING TOOL	NTS

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178326

Page 1 of 1

3.5000	$\pm .0005$	3.5001	✓
2.00	$\pm .01$	2.001	✓
4.40	$\pm .01$	4.401	✓
.05x45°	$\pm .01 \pm .5^\circ$	.05x45°	✓
R.03	$+0 -.01$	R.03	✓
30°	$\pm .5^\circ$	30°	✓
-.12	$\pm .01$	-.125	✓
1.805	$\pm .005$	1.805	✓
2.8740	$\pm .0005$	2.8743	✓
-.21	$\pm .01$	-.210	✓
1.40	$\pm .01$	1.400	✓
4.00	$\pm .01$	4.006	✓
6.50	$\pm .01$	6.503	✓
2-12unf-3A		✓	✓
major ϕ 2.00	$+0 -.0114$	1.995	✓
minor ϕ 2.0387	$+0 -.0045$	2.036	✓

Measured by:	YL
Date:	18-7-16

Engineering Approval:
(If necessary)

Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>178326</u> Part No. <u>BST101896-13</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date :		Step #:		QTY Effective :		MRB (QSI042) Approval <i>M. Lee</i> <u>JULY 10/18</u>																																																																			
Description Work Order Deviation				Disposition		Completed By																																																																			
MAKE FROM 303/304/316/17-4 PH-H 900-H1160 AS REQUESTED BY PRODUCTION DO NOT ZINC PLATE * QTY 1 ONLY *				THIS DEVIATION IS ACCEPTABLE NO CHANGE TO FIT FORM OR FUNCTION		Lead hand / Supervisor Approval Verification																																																																			
						<i>D.F 18-07-16</i>																																																																			
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